

Work Order ID 130520

130520

Page 1

Item ID: D4543-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Retainer, Outer, RH

Start Date: 3/13/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MCS

Date: 15-03-13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4543	B								

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1- Cut D4543-1F as per dwg

Prog rev: B

Dwg rev: B

2- Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

⑥

DL15/03/21

⑥

DL15/03/21

6061-032

Friday, March 13, 2015 12:56:52 PM

130520

Page 3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Retainer, Outer, RH

Stop *NS2*

Start Date: 3/13/2015 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 3/13/2015 **Req'd Qty:** 6.00

6

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

160	QC7-Inspect Chemical Conversion Coat	0.00	
160			
QC	Memo	0.00	
Quality Control			

MAR 26 2

170	Identify as per dwg & Stock Location	87680	0.00			
170						
Packaging						
	Memo		0.00			
Packaging						



DAS
 26
~~9-89~~

MAR 27 2015

Work Order ID 130520

Friday, March 13, 2015 12:56:52 PM

130520

Page 4

Item ID: D4543-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Retainer, Outer, RH

Stop ***NS2***

Start Date: 3/13/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

15/3/30
15-3-30

Picklist Print

Friday, March 13, 2015 12:56:55 PM

Page 1

Work Order ID: 130520

130520

Parent Item: D4543-2

D4543-2

Parent Item Name: Retainer, Outer, RH

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP revA 12.01.12 New Issue EC verified by:DD IPP REV:B
12.02.24 as per dwg reva DD verf:EC IPP REV:C 13.04.23 as
per dwg revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased		No		100	sf	249.5213	0.611	4			

M6061T6S 032

6061-T6 Sheet 0.032"

DC 15/03/21

Location

Loc Qty

Loc Code

MAT021

249.5213

m130387

61.6667

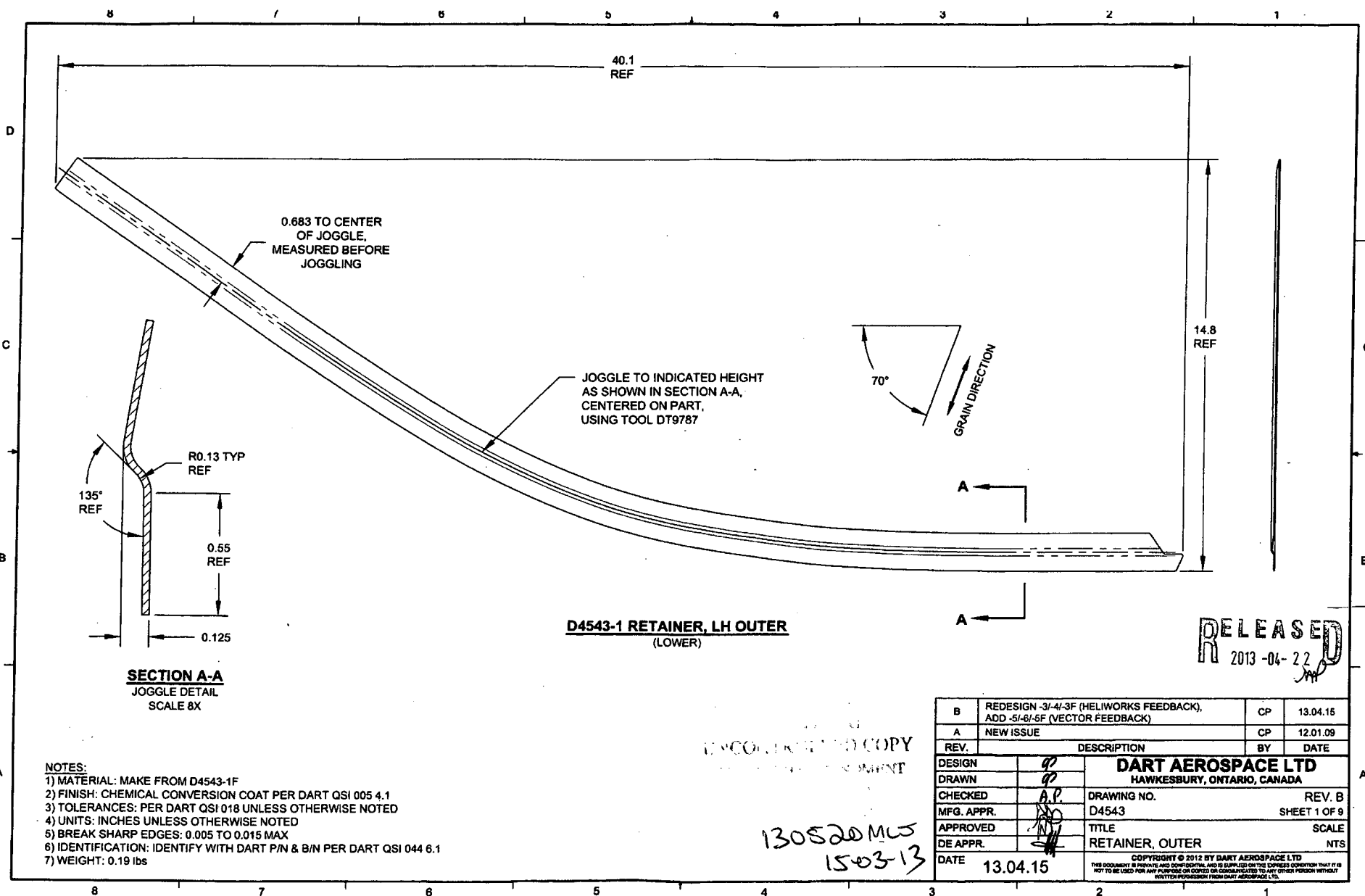
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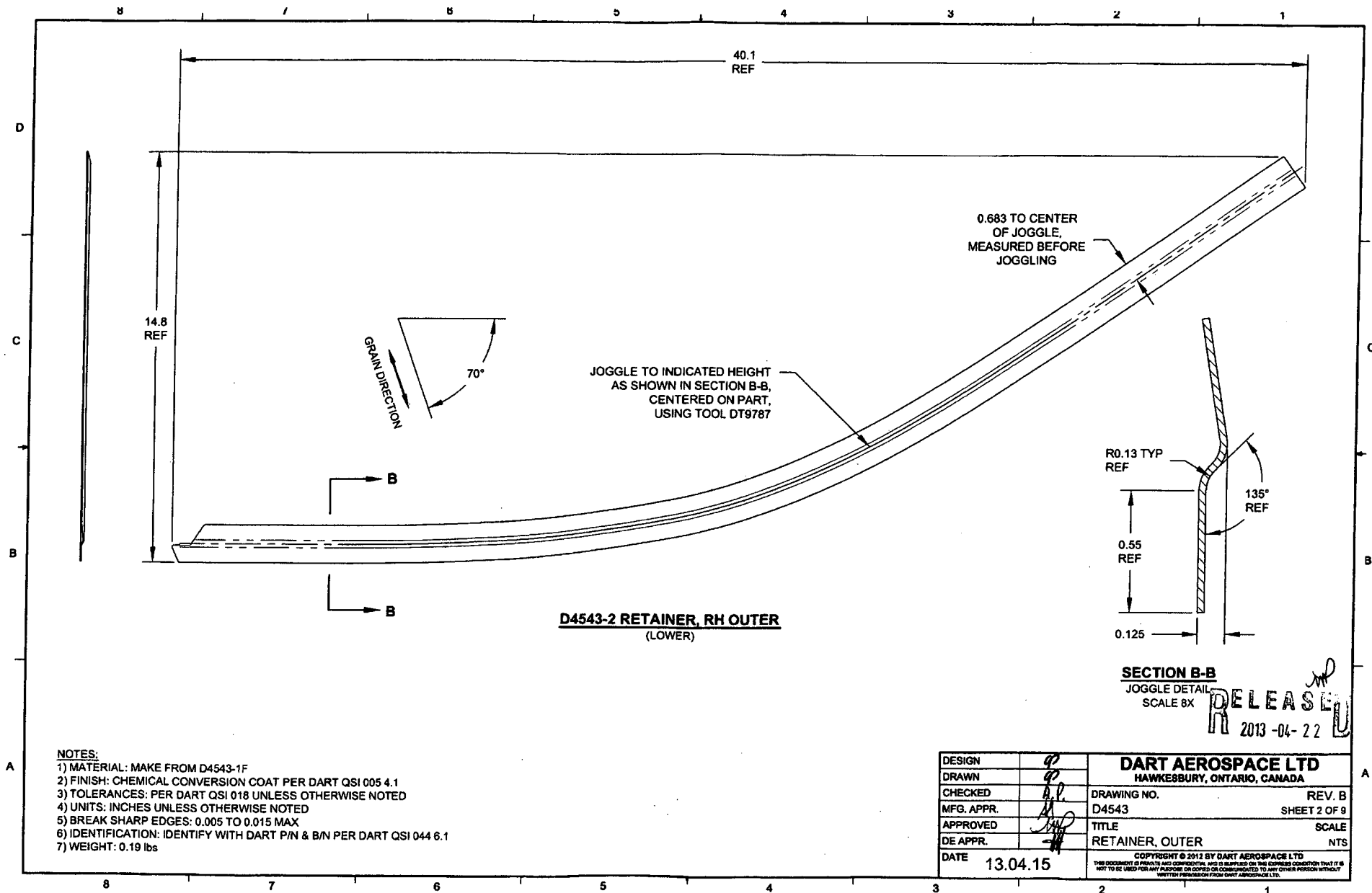
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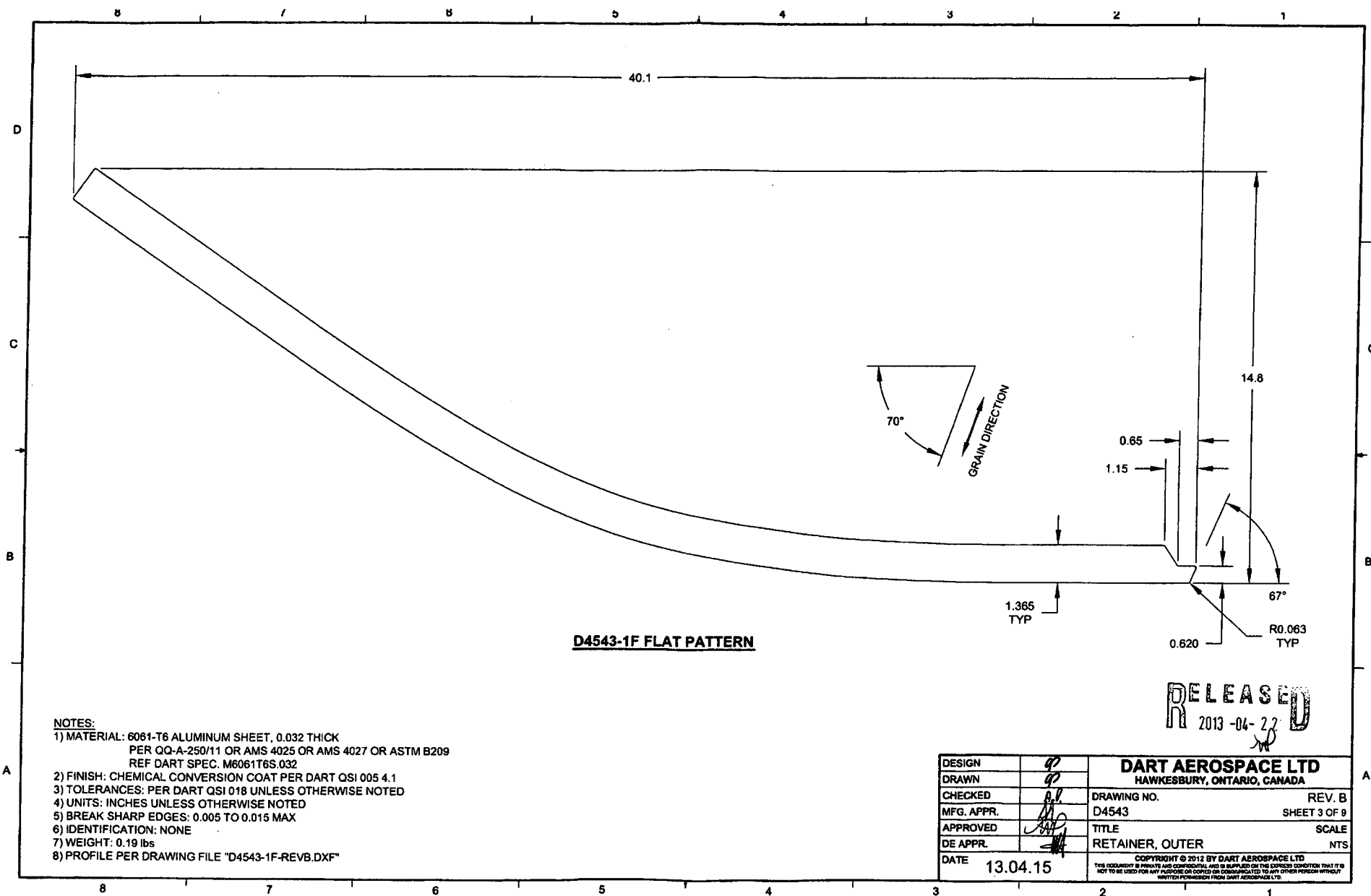
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129.4

4.2





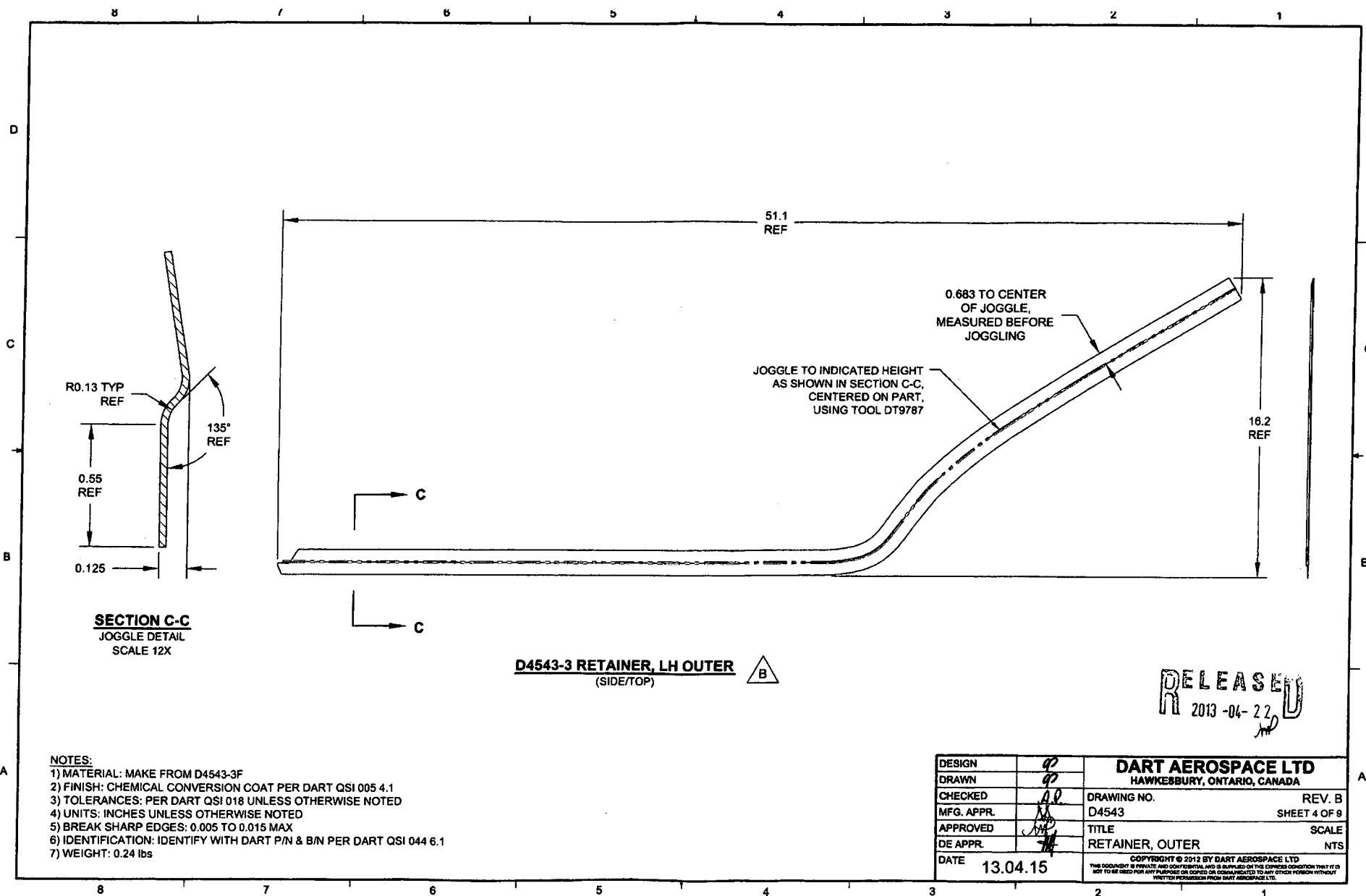


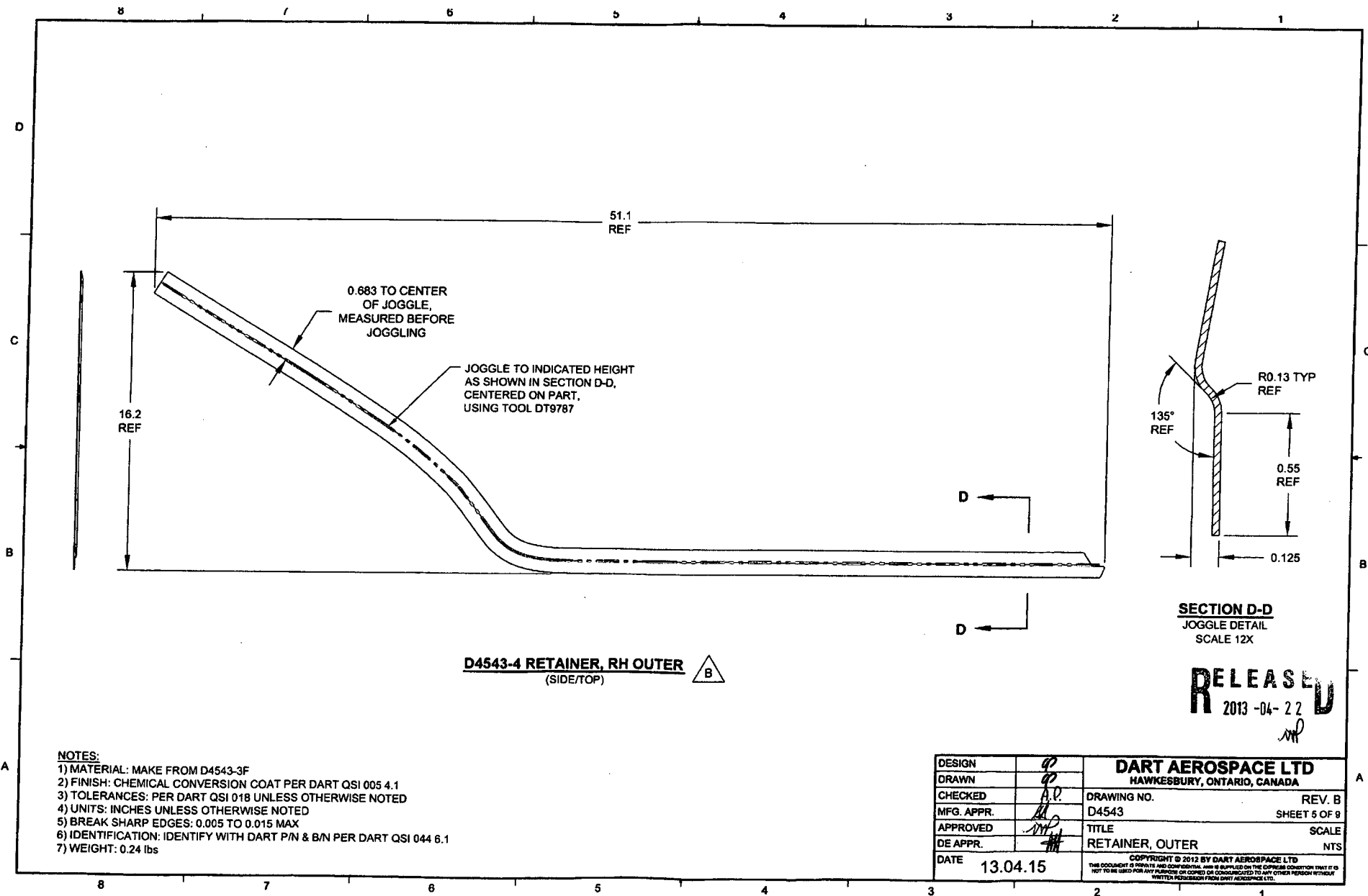
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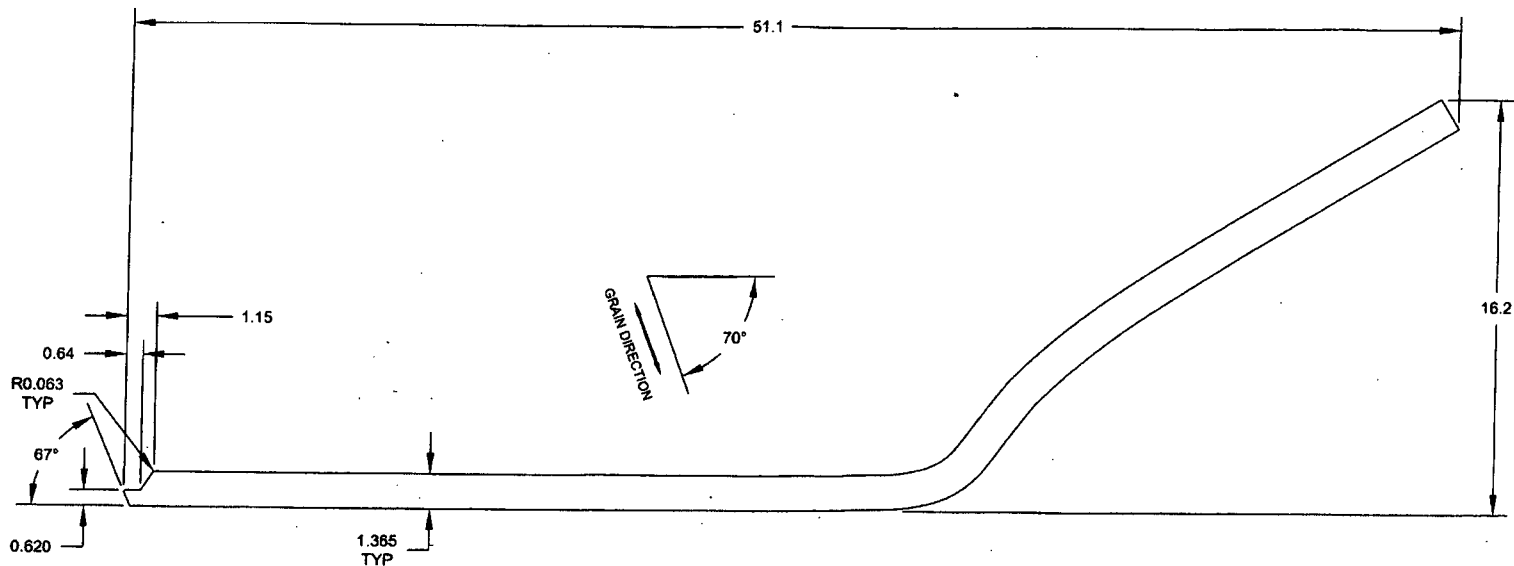
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs
- 8) PROFILE PER DRAWING FILE "D4543-1F-REVB.DXF"

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2013-04-22

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	92	DRAWING NO.	REV. B
MFG. APPR.	92	D4543	SHEET 3 OF 9
APPROVED	92	TITLE	SCALE
DE APPR.	92	RETAINER, OUTER	NTS
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D4543-3F FLAT PATTERN

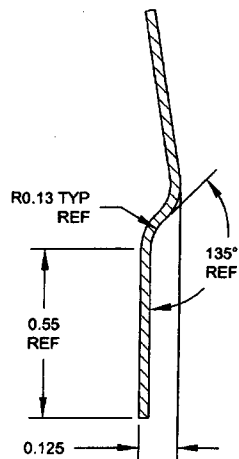


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2013-04-22

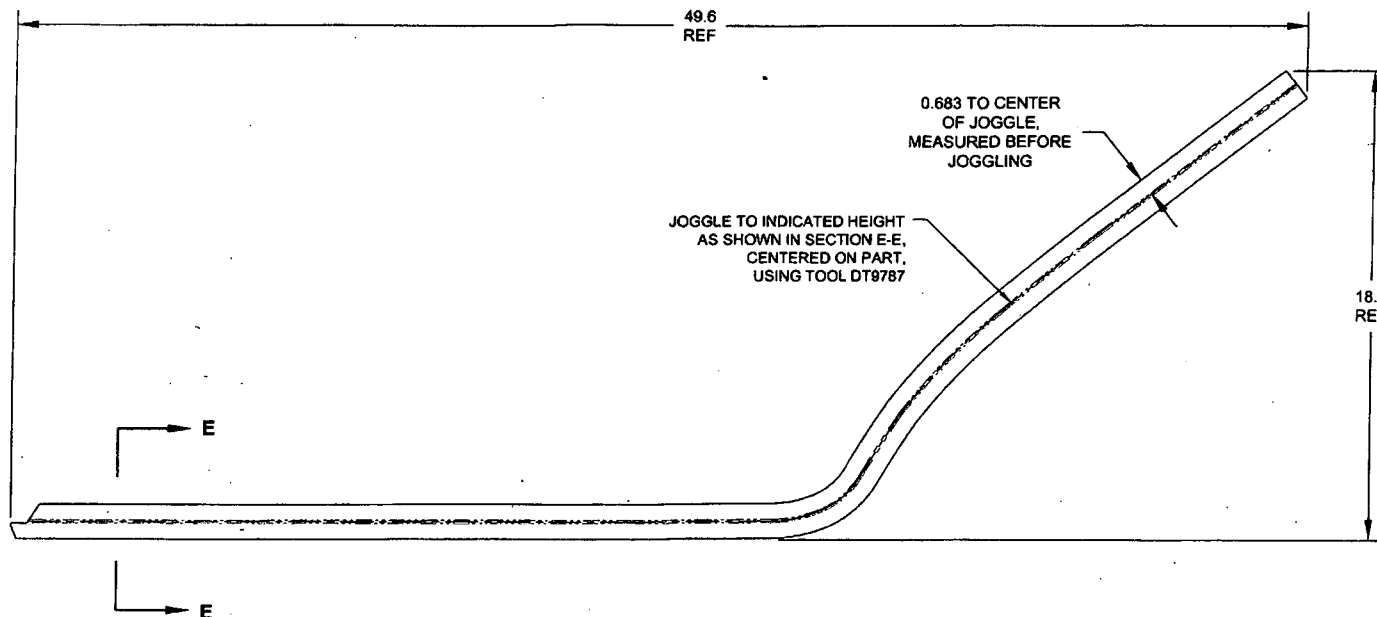
NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs
- 8) PROFILE PER DRAWING FILE "D4543-3F-REVB.DXF"

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SECTION E-E
JOGGLE DETAIL
SCALE 12X



D4543-5 RETAINER, LH OUTER
(SIDE/TOP) B

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2013-04-22
RP

NOTES:

- 1) MATERIAL: MAKE FROM D4543-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

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8 7 6 5 4 3 2 1

D

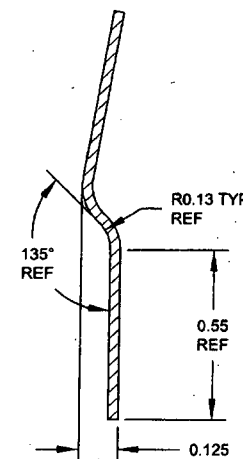
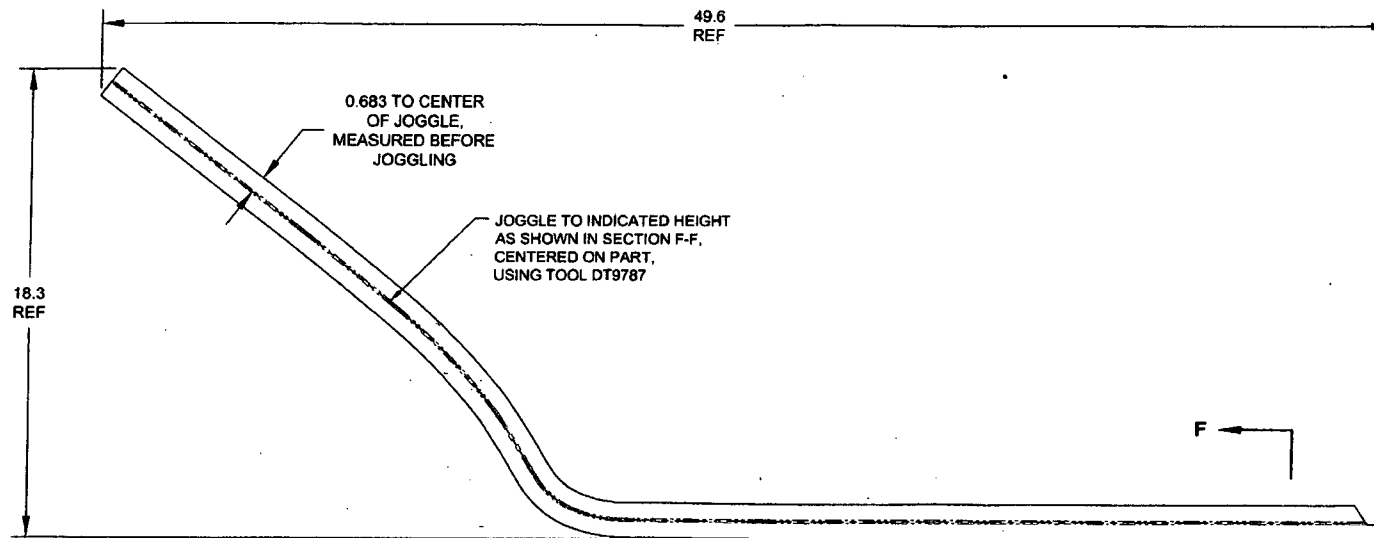
D

C

C

B

B



SECTION F-F
JOGGLE DETAIL
SCALE 12X

D4543-6 RETAINER, RH OUTER
(SIDE/TOP)



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2013-04-22

NOTES:

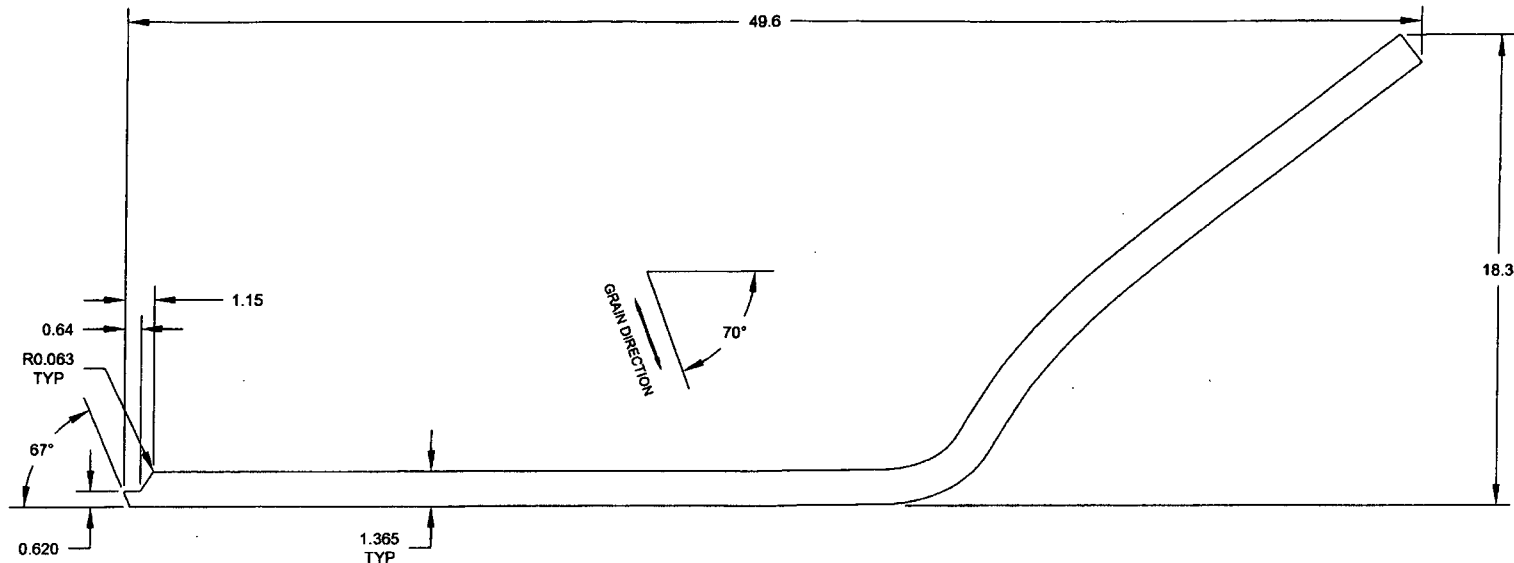
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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

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8 7 6 5 4 3 2 1

A

A



D4543-5F FLAT PATTERN



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2013-04-22

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- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
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REF DART SPEC. M8061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs
- 8) PROFILE PER DRAWING FILE "D4543-5F-REV-B.DXF"

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